

Work Order ID 92345 - *Split 2/2*

October-29-12 1:24:51 PM

92345

Page 1

Item ID: D4095-043

Revision ID:

Item Name: Wearplate Assembly

Start Date: 29/10/2012 Start Qty: 10.00

Required Date: 12/11/2012 Req'd Qty: 10.00

Reference:

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

~~*10*~~

~~*10*~~

6

Approvals:

Process Plan: *MLS*

Date: *12-10-29* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4095	B

100

100

Waterjet

FLOW CNC Waterjet

304.063

FLOW WATER JET

Memo

1-Cut as per Dwg (D4095-3)

Dwg Rev: *B*

Prog Rev: *B*

2-Deburr if necessary

0.00

0.00

10

0

Jm 12-10-29

110

110

QC

Quality Control

QC2- Inspect parts off machine FAL/FAIB

Memo

0.00

0.00

10

0

Jm 12-10-29

120

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

DAS
15
2-89

12.10 30

10

Work Order ID 92345

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92345

Page 2

Item ID: D4095-043
 Revision ID:
 Item Name: Wearplate Assembly
 Start Date: 29/10/2012 Start Qty: 10.00
 Required Date: 12/11/2012 Req'd Qty: 10.00
 Reference:

Accept

N9000040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1- bend section C-C first 2- Form on Brake as per Dwg D4095 using Jigs DT 8179 and DT 8155 3- Form Joggles (2) as per Dwg D4095 on brake using Jig DT 8157	0.00 0.00				10			23 14/11/12
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo Ensure joggle as per dwg D4095	0.00 0.00				10			12/11/12
150 *150* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch: <u>M123669</u> Large Fab Memo	0.00 0.00				6			12-11-16 JBL

Work Order ID 92345

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92345

Page 3

Item ID: D4095-043

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 29/10/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				(6)	12-11-16		DAS 09 12-11-16
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(6)	12-11-16		DAS 09 12-11-16
180 *180* HandFinish Hand Finishing	Memo COAT ENTIRE TOP (CONCAVE) SURFACE WITH ROCKGUARD AS PER DWG A/R ROCKGUARD BATCH: 123307	0.00 0.00				6	0	0	12-11-17

Work Order ID 92345

October-29-12 1:24:51 PM

92345

Page 4

Item ID: D4095-043

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 29/10/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/11/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<u>x6</u>			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-1</u> Memo	0.00 0.00				<u>x6</u>	<u>of Jul 11/19</u>		
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>12/11/19</u> <u>MF</u> <u>12-11-19</u>

Picklist Print

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Page 1

Work Order ID: 92345

Parent Item: D4095-043

Parent Item Name: Wearplate Assembly

92345

D4095-043

Start Date: 29/10/2012

Required Date: 12/11/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A new issue DD 10.04.26 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

422.6780

2.275

~~23.94737~~

**

24.0

M304S16GA

304/316 Sheet .063

Jm 12-10-2

Location

MAT020

Loc Qty

422.678

122245

51.078

122753

77.9

123136

293.7

Loc Code

122753

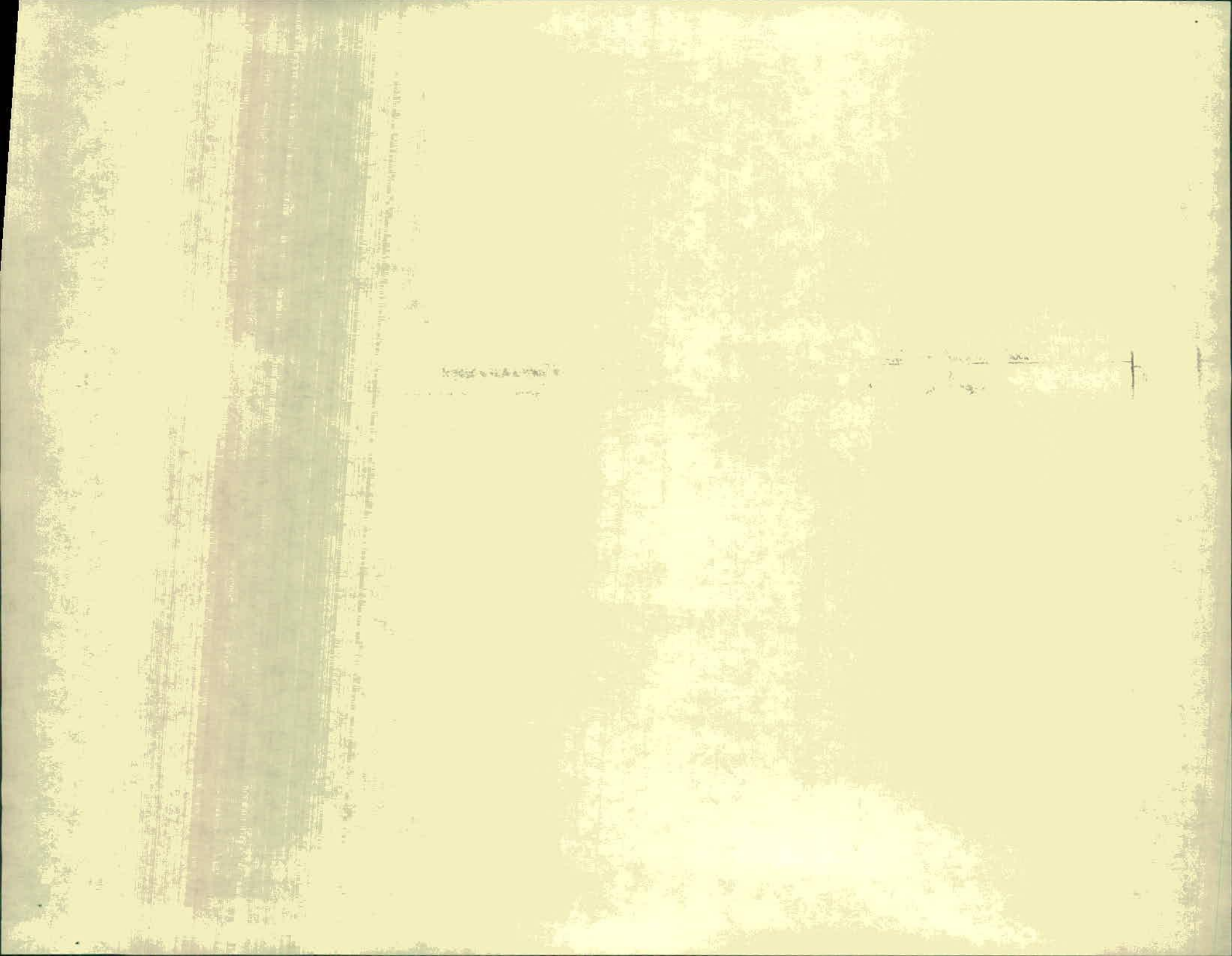
DART AEROSPACE LTD		Work Order:	92345
Description: Wearplate		Part Number:	D4095-3
Inspection Dwg: D4095	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST


Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	0.191"	-		✓	mmol
0.300	+/-0.010	0.301"	✓		✓	
0.300	+/-0.010	0.302"	-		✓	
2.432	+/-0.010	2.438"	✓		✓	
3.227	+/-0.010	3.230"	-		✓	
4.06	+/-0.030	4.055"	✓		✓	
2.50	+/-0.030	2.503"	-		✓	
4.98	+/-0.030	4.988"	-		✓	
8.43	+/-0.030	8.425"	-		✓	Produ J02
11.50	+/-0.030	11.510"	-		✓	
21.750	+/-0.010	21.750"	-		T	Produ J03
3.500	+/-0.010	3.500"	-		✓	
12.22	+/-0.030	12.22"	-		T	
6.000	+/-0.010	6.007"	-		✓	
12.100	+/-0.010	12.107"	-		T	
21.00	+/-0.030	21.00"	-		T	
30.000	+/-0.010	30.000"	-		T	
36.000	+/-0.010	36.000"	-		T	
38.88	+/-0.030	38.88"	-		T	
0.063	+/-0.010	0.059"	-		✓	

Measured by: Jm	Audited by: DAS	Preliminary Approval:
Date: 12-10-29	Date: 12/10/30	Date:

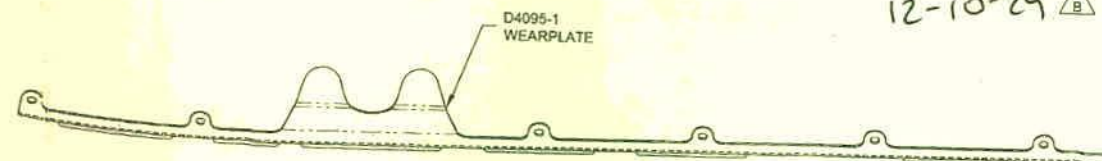
Rev	Date	Change	Revised by	Approved
A	11.02.18	New Issue P/O D4095-043	KJ	
B	11.11.08	Dimensions updated per Dwg Rev B	KJ	



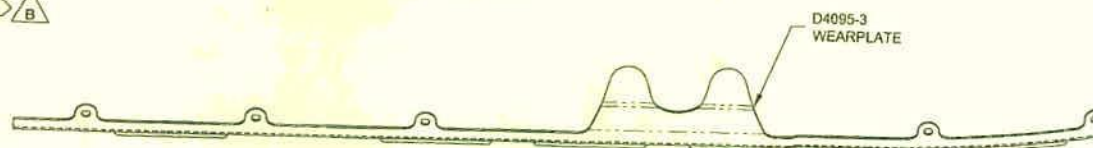
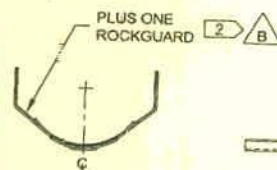
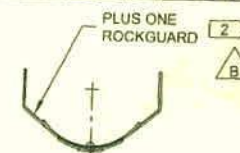
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 92345 MJS

12-10-29 

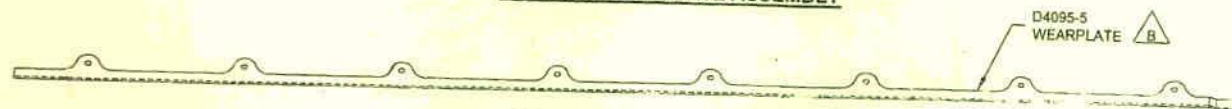
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	PART NUMBER	DESCRIPTION
1	X						D4095-041	WEARPLATE ASSEMBLY
2		X					D4095-043	WEARPLATE ASSEMBLY
3			X				D4095-045	WEARPLATE ASSEMBLY
4				X			D4095-047	WEARPAD ASSEMBLY
5					X		D4095-049	WEARPAD ASSEMBLY
6						X	D4095-051	WEARPAD ASSEMBLY
7	1						D4095-1	WEARPLATE
8		1					D4095-3	WEARPLATE
9			1				D4095-5	WEARPLATE
10				1			D4095-7	WEARPAD
11					1		D4095-9	WEARPAD
12						1	D4095-11	WEARPAD
13	A/R	A/R	A/R	A/R	A/R	A/R	4715 (4714)	PLUS ONE ROCKGUARD BLACK (TAN)



D4095-041 WEARPLATE ASSEMBLY




D4095-043 WEARPLATE ASSEMBLY



D4095-045 WEARPLATE ASSEMBLY



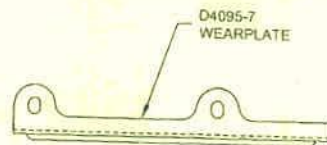
D4095-041/-043/-045/-047/-049/-051 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714 OR 4715, 0.02-0.04 THICK 
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4095-0XX" AND BIN "BXXXXX" USING REMOVABLE TAG PER QSI 044 6.6
- 7) WEIGHT: D4095-041= 3.08 lbs; D4095-043= 3.08 lbs; D4095-045= 2.00 lbs; D4095-047= 0.48 lbs; D4095-049= 0.42 lbs; D4095-051= 0.37 lbs
- 8) PARTS ARE SYMMETRIC ABOUT \bar{C}

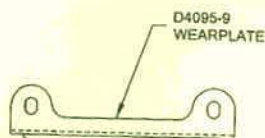
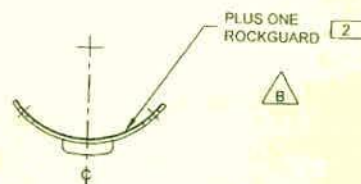
B	REVISED D4095-1A-1F/33F; 4715 PLUS ONE ROCKGUARD REPLACES D4095-1A-1; ADDED D4095-5A-7-9A-11; REVISED HARDCOAT DESIGN; REVISED NOTE 2	XDF	11.10.18
A	NEW ISSUE	MB	10.04.20
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4095	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
DATE	11.10.18	<small>COPYRIGHT © 2018 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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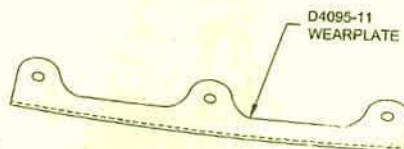
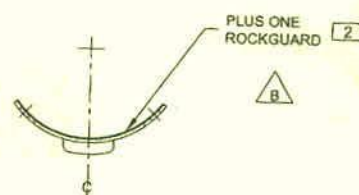




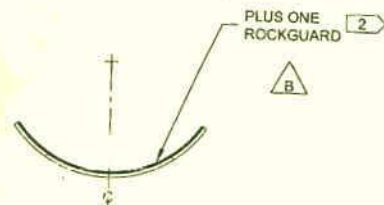
D4095-047 WEAR PAD ASSEMBLY



D4095-049 WEAR PAD ASSEMBLY



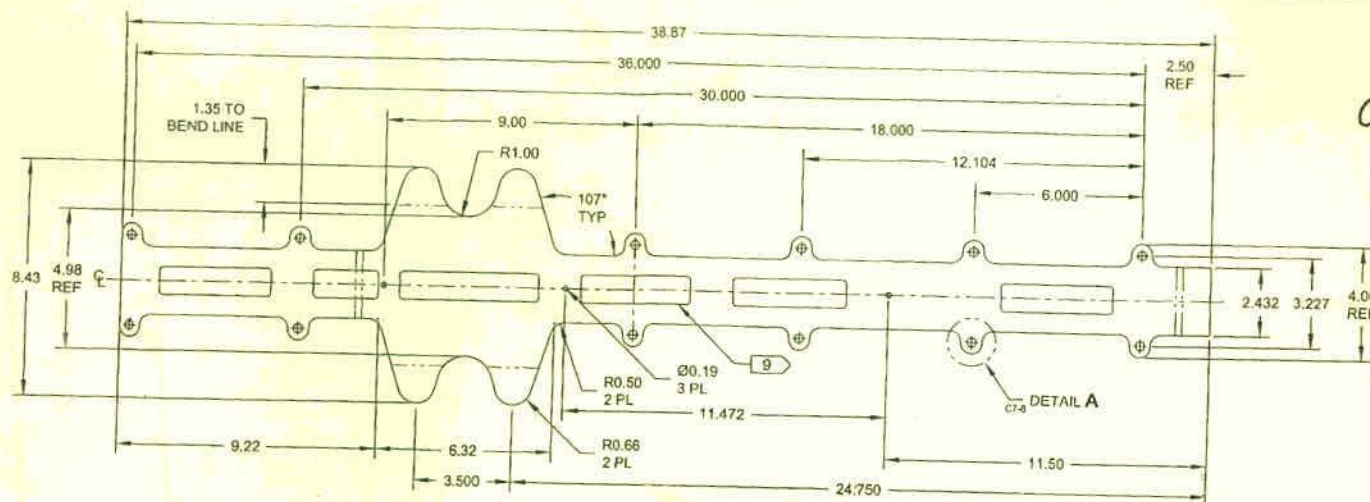
D4095-051 WEARPAD ASSEMBLY



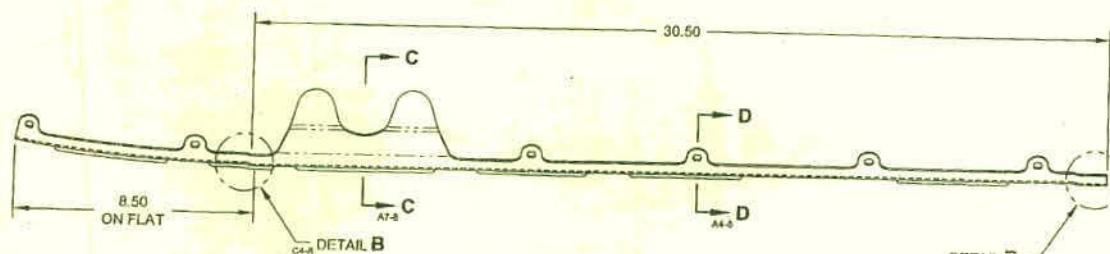
92345

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D4095-1F FLAT PATTERN



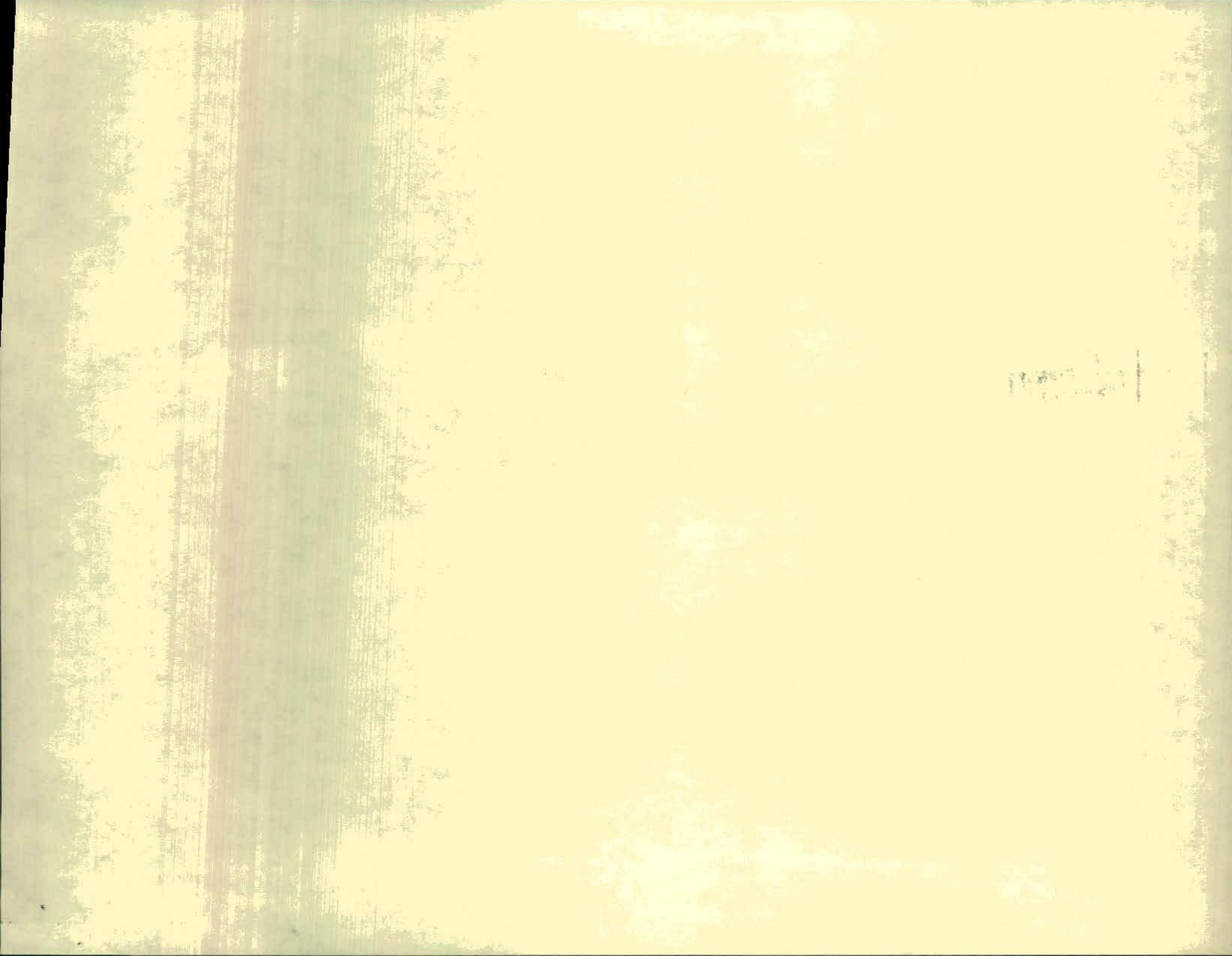
D4095-1 BENDING DETAIL
(MAKE FROM D4095-1F)

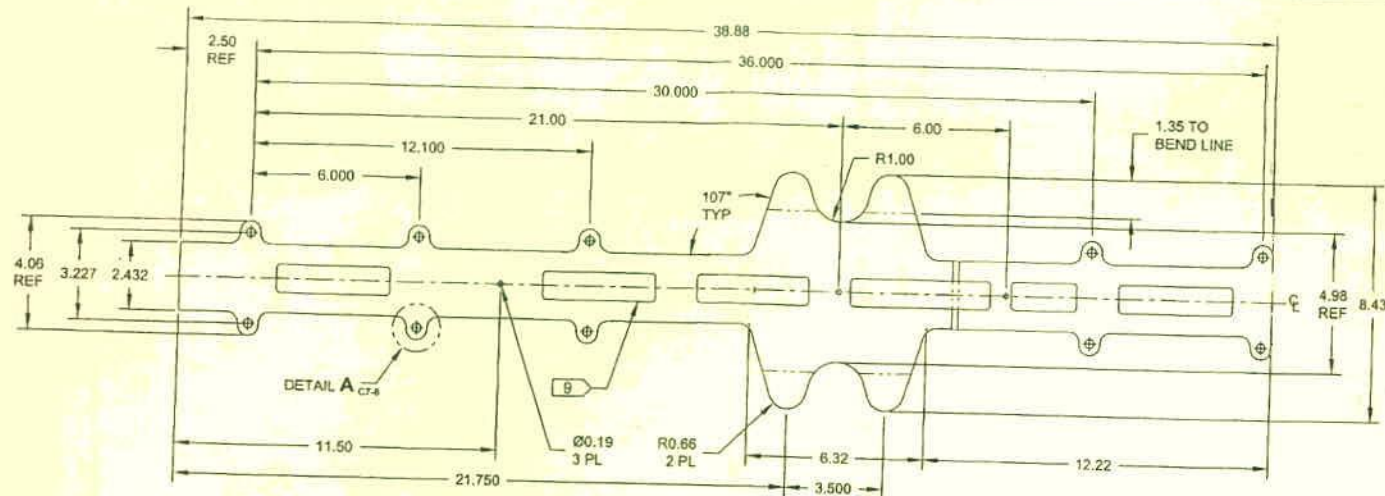
D4095-1, -1F, -3, -3F, -5, -5F, -7, -7F, -9, -9F, -11, -11F NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR AMS 5524 (316), OR ASTM A240 OR ASME SA240
REF DART MATERIAL SPEC M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4095-1 = 3.00 lbs; D4095-3 = 3.00 lbs; 4095-5 = 1.96 lbs; D4095-7 = 0.47 lbs; D4095-9 = 0.41 lbs; D4095-13 = 0.36 lbs
- 8) WELDING: PER DART QSI 004
- 9) PARTS ARE SYMMETRIC ABOUT C

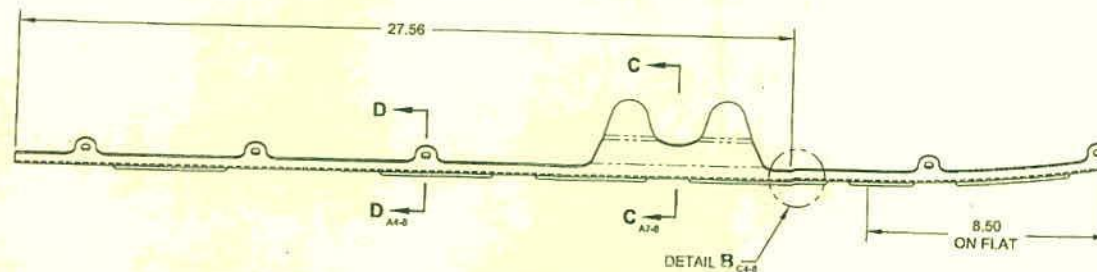
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D4095-3F FLAT PATTERN 1

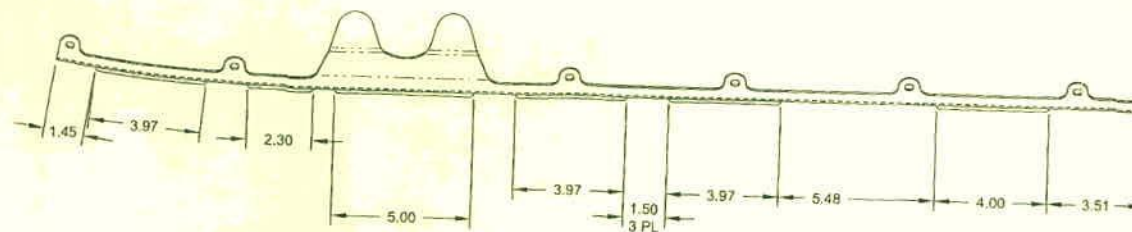



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(MAKE FROM D4095-3F)

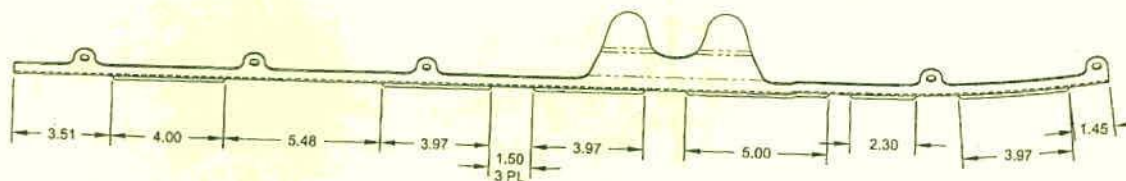
RELEASE
2011-10-31


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CHECKED	10	DRAWING NO.	REV. B
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92345



D4095-1 WELDING DETAIL 

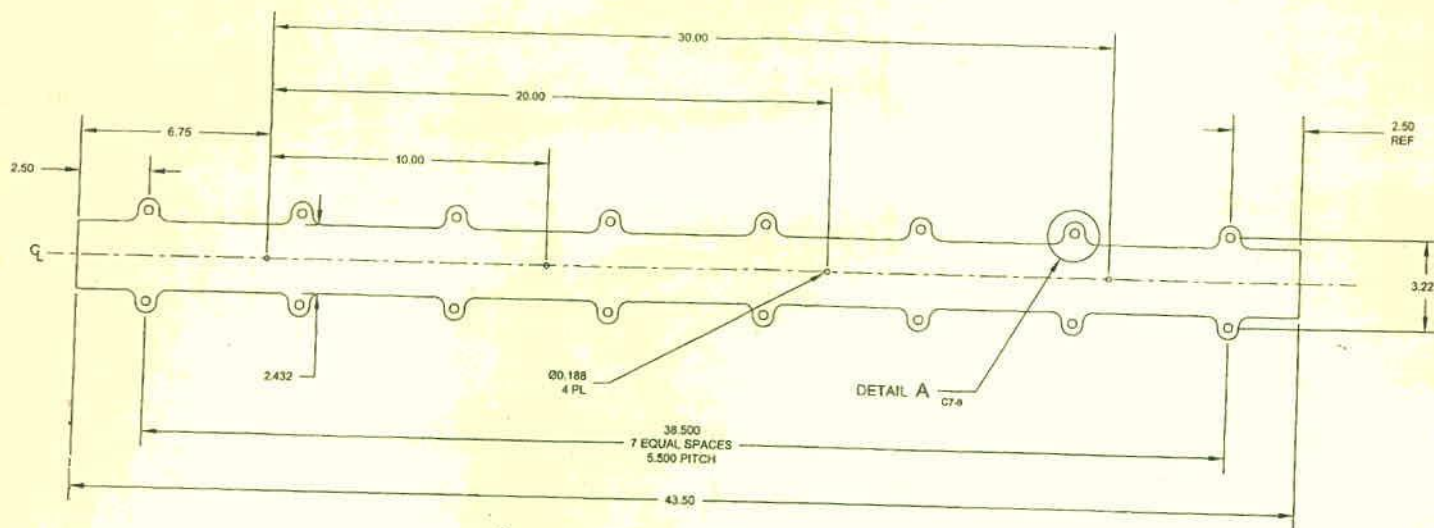


D4095-3 WELDING DETAIL 

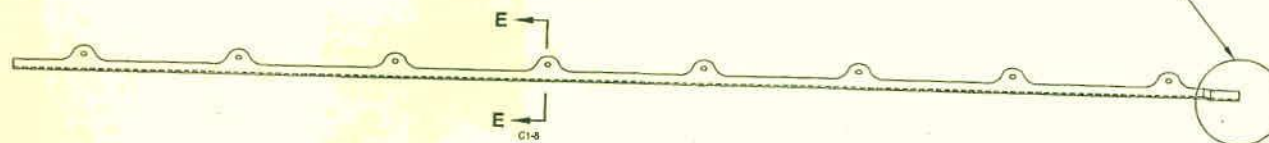
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CHECKED	<i>AP</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>AP</i>	D4095	SHEET 5 OF 8
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	WEARPLATE	NTS
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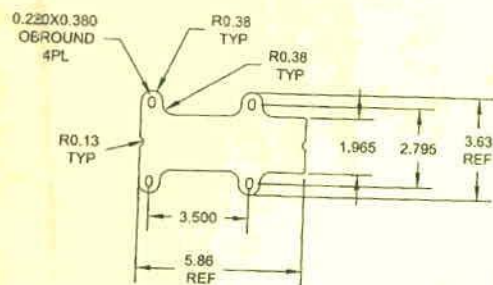
D4095-5F FLAT PATTERN



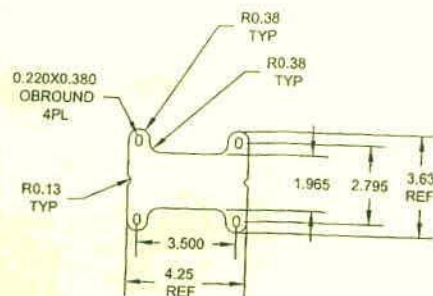
D4095-5 BENDING DETAIL
(MAKE FROM D4095-5F)

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2011-10-31
NND

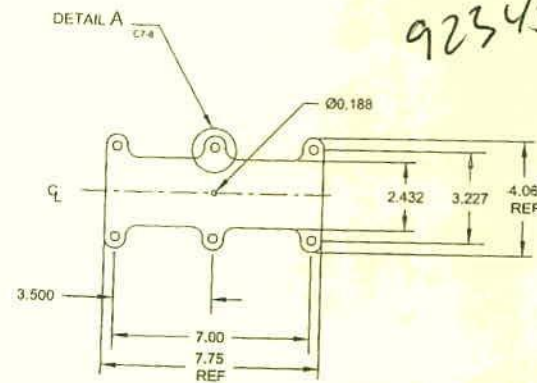
DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	NO	DRAWING NO.	REV. B
MFG. APPR.	NO	D4095	SHEET 6 OF 8
APPROVED	NO	TITLE	SCALE
DE APPR.	NO	WEARPLATE	NTS
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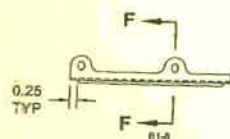
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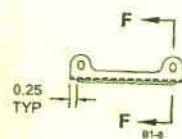
D4095-9F FLAT PATTERN



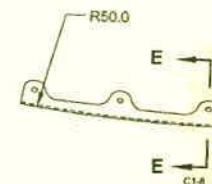
D4095-11F FLAT PATTERN



D4095-7 LONGITUDINAL BEND
(MADE FROM D4095-7F)



D4095-9 LONGITUDINAL BEND
(MADE FROM D4095-9F)

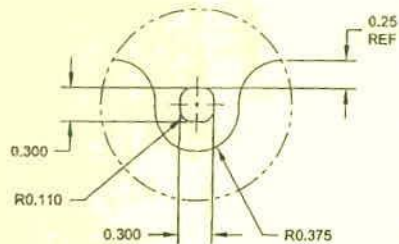


D4095-11 BENDING DETAIL
(MAKE FROM D4095-11F)

2011-10-31

DESIGN		DART AEROSPACE USA, INC
DRAWN	XDF	KENT, WA
CHECKED	10	DRAWING NO. REV. B
MFG. APPR.	10	D4095 SHEET 7 OF 8
APPROVED	10	TITLE SCALE
DE APPR.	10	WEARPLATE NTS
DATE	11.10.18	

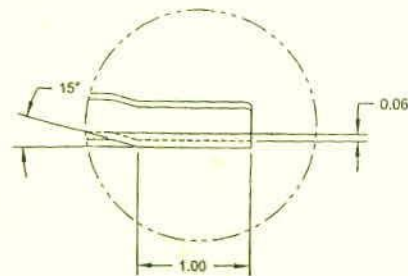
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DETAIL A: TAB DETAIL

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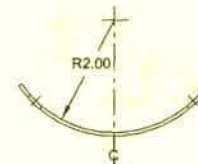
C3-3
C6-4
C3-6
C2-7



DETAIL B: JOGGLE DETAIL

SCALE 4X

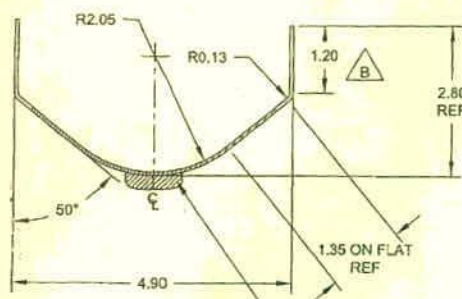
B2-3
B6-3
B3-4
B2-6



SECTION E-E

SCALE 2X

B5-6
B2-7

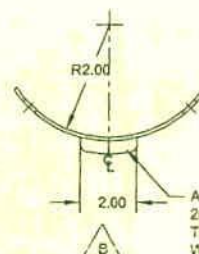


SECTION C-C

SCALE 2X

B5-3
B4-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

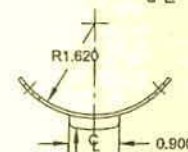


SECTION D-D

SCALE 2X

B4-3
B5-4

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK



SECTION F-F

SCALE 2X

B5-7
B1-7

APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

RELEASED
2011-10-31
NP

DESIGN		DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D4095	SHEET 8 OF 8
APPROVED	10	TITLE	SCALE
DE APPR.	10	WEARPLATE	NTS
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